

Work Order ID 84842

May-24-12 7:58:09 AM

84842

Page 1

Item ID: D2724-042

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: 206L Step Assembly

Stop

NS2

Start Date: 24/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/28

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2724

Rev C

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2724-2 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding

2 ϕ 12
12-01-05

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap (One End Only) and lugs as per Dwg D2724 using Jig DT8898
followed by Jig
A/R AL ROD Batch: 120854
122130
Grind end cap welds flush

2 ϕ 12
12-07-09
Ac
12-07-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 2.00

2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

2 0 BE 12/6/12

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

8/10/12

AC BL

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

2X 0 M/L 12/6/12
RHX

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Quality Control

W/O:		WORK ORDER CHANGES					
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May-24-12 7:58:09 AM

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Page 4

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Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: 206L Step Assembly

Stop ***NS2***

Start Date: 24/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

DAS
15
12-08
12/07/17

XL
RH

190

Chemical Conversion Coat per QSI005 4.1

0.00

190

HandFinish

Memo

0.00

Hand Finishing

2 PG 12-7-17

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:30
OVEN TEMPERATURE: 320°F
FINISH TIME: 10:00

2X
RH
ML
12/07/17

M121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

May-24-12 7:58:09 AM

Page 5

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 24/05/2012 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 07/06/2012 **Req'd Qty:** 2.00 ***2***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

220

Wing Walk as per dwg QSI005 4.4 Batch M12 5050.00

220

HandFinish

Memo

0.00

Hand Finishing

230

QC3- Inspect Part Finish

0.00

230

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D2724-042

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 206L Step Assembly

Start Date: 24/05/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 07/06/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

240	Identify as per dwg & Stock Location: _____	0.00							
-----	---	------	--	--	--	--	--	--	--

240

Packaging

Memo

P1784829

0.00

Packaging

250	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

250

QC

Memo

0.00

Quality Control

12/2/19 @

12/7/20 JF

JNF
12-07-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 1

Work Order ID: 84842

84842

Parent Item: D2724-042

D2724-042

Parent Item Name: 206L Step Assembly

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2734		Manufactured	No			110	Each	51.0000	1	2			
D2734									**			12.07.05	
Step End Plate													

Location	Loc Qty	Loc Code
WA	51	
76985	5	
80682	16	
83322	30	

D3458-1		Manufactured	No			110	Each	19.0000	2	4			
D3458-1									**			12.07.05	
Step Mounting Plate													

Location	Loc Qty	Loc Code
WA	16	
82117	16	
WA002	2	
75609	2	
WA018	1	
63075	1	

D3458-3		Manufactured	No			110	Each	29.0000	2	4			
D3458-3									**			12.07.05	
Step Mounting Plate													

Location	Loc Qty	Loc Code
WA	24	
82116	24	
WA002	5	
75610	5	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

May-24-12 7:58:13 AM

Page 2

Work Order ID: 84842

84842

Parent Item: D2724-042

D2724-042

Parent Item Name: 206L Step Assembly

Start Date: 24/05/2012

Required Date: 07/06/2012

Start Qty: 2.00

Required Qty: 2.00

D2734

Manufactured No

160

Each

51.0000

1

2

D2734

**

Step End Plate

12.07.13

Location

Loc Qty

Loc Code

WA

384563

51

76985

5

80682

16

83322

30

2

D2622-120C

Manufactured No

100

Each

30.6100

1

2

D2622-120C

**

Step Extrusion

12.07.05

Location

Loc Qty

Loc Code

HALL

383894

16.37

46910

2

64409

6

66970

7.7

68293

0.25

72131

0.42

WA

4.88

81507

4.88

WA013

9.36

75781

2

77612

7.36

2

W/O:		WORK ORDER CHANGES					
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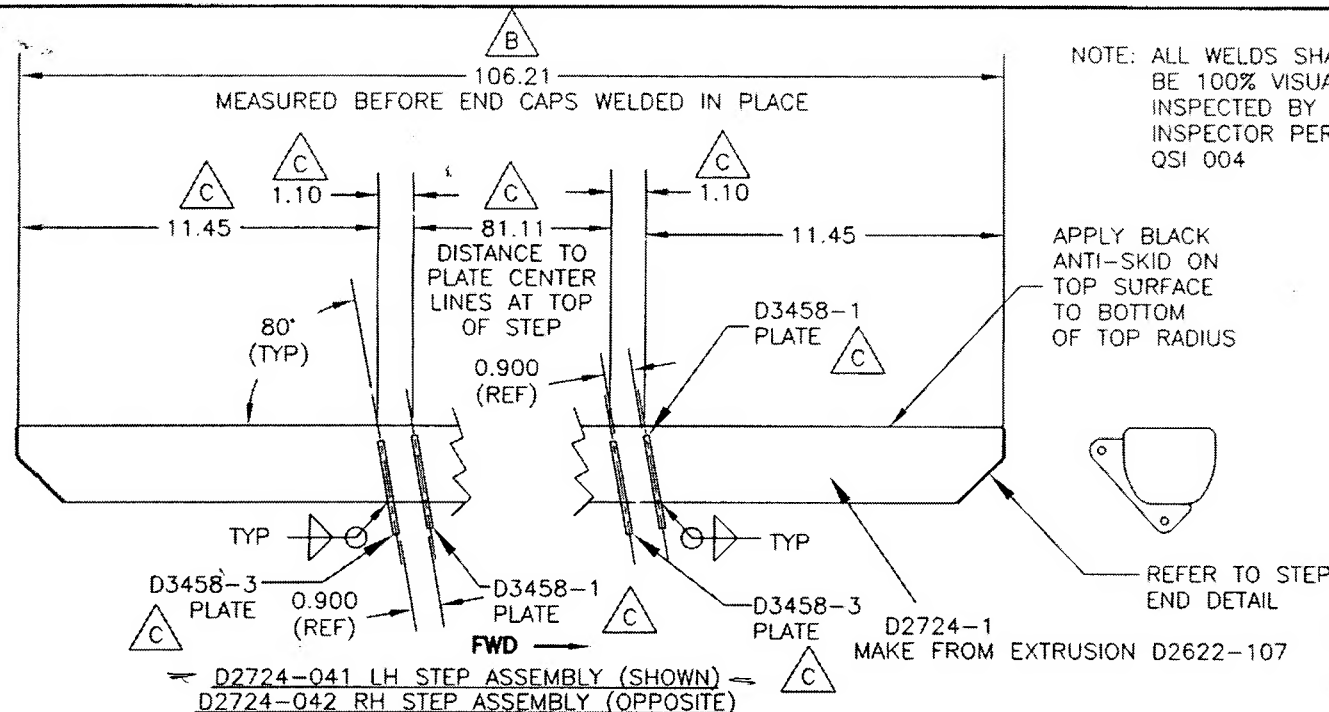
NOTE: Date & initial all entries

DART

RELEASED

05.11.14

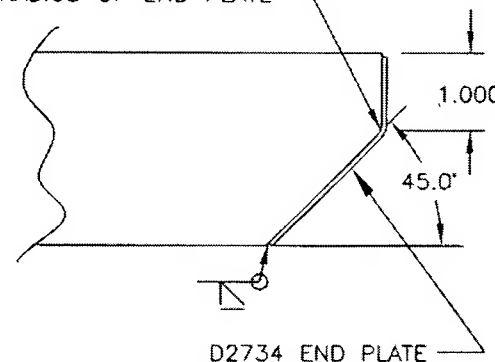
NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



SHOP CO.
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENTS

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

TYPICAL STEP END DETAIL

NOT TO SCALE

WORK ORDER
NO. 84842 MLJ
12/05/28

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

REV. C
SHEET 1 OF 1
SCALE
NTS

TITLE
206L/407 STEP ASSEMBLY

NEW ISSUE

UPDATED WELD DETAIL
REVISED TOLERANCES

RE-DESIGN, ADD D3458-1/-3

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